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JAPANESE INDUSTRIAL STANDARD

Graphical Symbols for Process Chart

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Graphical Symbols for Process Chart

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1. Scope

This Japanese Industrial Standard specifies the graphical symbols for process chart to be used to indicate on drawing the process for manufacturing products in mining and manufacturing industries.

Remark: The process chart herein shows the processes to give changes on raw materials, working materials, parts or products, and means the process series indicating the sequence relationship concerning the individual elemental processes constituting the process and their elemental processes.

Furthermore, the elemental processes shall be classified into working, transportation, stagnation and inspection, further, the stagnation, into storage and congestion, and the inspection, into quantity inspection and quality inspection.

2. Classification of Graphical Symbols for Process Chart

Graphical symbols shall be classified into basic graphical symbols and auxiliary graphical symbols.

The basic graphical symbols are the symbols to be used for indicating the elemental processes and are classified into each symbol of working, transportation, storage, congestion, quantity inspection and quality inspection. Auxiliary graphical symbols are the symbols to be used for indicating on drawing the state of series in the process series, and are classified into each symbol of flow line, division and omission.

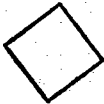
3. Basic Graphical Symbols

The basic graphical symbols are specified as shown in Table 1.

Table 1. Basic Graphical Symbols

No.	Elemental process	Designation of symbol	Symbol	Meaning	Remarks
1	Working	Working		This symbol indicates the process to give change in shapes and properties for raw material, working material, part or product.	
2	Transportation	Transportation		This symbol indicates the process to give change in position of raw material, working material, part or product.	The diameter of transportation symbol shall be 1/2 to 1/3 of that of working symbol. Instead of symbol O, the symbol  may be used, provided that this symbol does not mean the direction of transportation.
3	Storage	Stagnation		This symbol indicates the process storing the raw material, working material, part or product according to plan.	
4		Congestion		This symbol indicates the state in congestion of raw material, working material, part or product in reverse of plan.	

Table 1 (Continued)

No.	Elemental process	Designation of symbol	Symbol	Meaning	Remarks
5	Inspection	Quantity inspection		This symbol indicates the process to obtain the difference of the results in comparison with the reference by measuring the quantity of raw material, working material, part or product.	
6		Quality inspection		This symbol indicates the process to judge the compliance of the lot or good quality of the piece by testing the quality characteristics of raw material, working material, part or product and by comparing the results with the reference.	

4. Auxiliary Graphical Symbols

The auxiliary graphical symbols are specified as shown in Table 2.

Table 2. Auxiliary Graphical Symbols

No.	Designation of symbol	Symbol	Meaning	Remarks
1	Flow line		This symbol indicates the relationship of sequence for elemental processes.	If the relationship of sequence is ambiguous, its direction shall be indicated clearly by describing arrow mark at the end or intermediate part of the flow line. The intersecting part of flow lines shall be indicated by  .
2	Division		This symbol indicates the division of controls in process series.	
3	Omission		This symbol indicates the omission of a part of process series.	

Reference

1. Method of Using Graphical Symbols for Process Chart

1.1 Process Chart The process chart means the chart indicating the process of manufacturing products by use of graphical symbols for process chart, and shall be as follows:

- (1) The process chart may be designated as process analysis chart or process plan chart according to its purpose of use.
- (2) In process chart, the beginning state and ending state of process series shall be indicated by using storage symbols.
- (3) The process chart shall, as a rule, be indicated longitudinally according to the relationship of sequence of elemental process.
- (4) If the joining or branching portion exists in the process series, the flow lines shall be described as shown in Reference Fig. 1, and the main series be indicated at the center of the process chart.

Reference Fig. 1 The method shown in (1) is used in the case where the raw materials, working materials, parts or products join or branch between the elemental processes, as frequently seen in assembling production processes.

Reference Fig. 1 The method shown in (2) is used in the case where the raw materials, working materials, parts or products join or branch between the elemental processes, as frequently seen in equipment production processes.